

Work Order ID 59804

Friday, June 11, 2010 12:54:47 PM



Page 1

Item ID: D2281

Accept



Setup Start



Revision ID:

Item Name: Jack Saddle

Stop



Start Date: 6/10/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 10-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281 ☐ Dwg Rev: G ☐ Prog Rev: G ☐ 2-
Deburr if necessary10-6-21

(49)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-6-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 10/6/21

count
(49)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 59804

Friday, June 11, 2010 12:54:47 PM



Page 2

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Start Date: 6/10/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo
Debur

u/as

0.00

0.00

140



Brake NC

NC BRAKE

Memo

Form as per D2281 using D2281-T2

0.00

0.00

SB 06/06/24

#9

150



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 06/06/24

count
245

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 59804

Friday, June 11, 2010 12:54:47 PM



Page 3

Item ID: D2281

Accept



Setup Start



Revision ID:

Item Name: Jack Saddle

Stop



Start Date: 6/10/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | Identify as per dwg & Stock Location: <u>261</u> | 0.00 | | | | | | | |
| | Packaging | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | Packaging | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| | QC | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | Quality Control | | | | | | | | |

10-6-25

(49)

SP

10/06/289

C210/6125

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, June 11, 2010 12:54:52 PM

Page 1

Work Order ID: 59804

Parent Item: D2281

Parent Item Name: Jack Saddle

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B ☐ 06.07.17 ☐ waterjet ☐ EC ☐

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S14GA | | Purchased | No | | | 100 | sf | 135.2608 | 0.125 | 5.263158 | 6.2 | | |



304SS sheet .080



IB 10-6-21

Location

Loc Qty

Loc Code

MAT20

135.2608

113295

135.2608

113295

(49)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | | | |
|---------------------------------|---------------|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | 59804 |
| Description: Jack Saddle | | Part Number: | D2281 |
| Inspection Dwg: D2281 | Rev: G | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 4.468 | +/-0.010 | 4.477 | ✓ | | | |
| 4.114 | +/-0.010 | 4.114 | ✓ | | | |
| 2.933 | +/-0.010 | 2.942 | ✓ | | | |
| 1.535 | +/-0.010 | 1.540 | ✓ | | | |
| 0.354 | +/-0.010 | .355 | ✓ | | | |
| 0.354 | +/-0.010 | .353 | ✓ | | | |
| 0.604 | +/-0.010 | .604 | ✓ | | | |
| 2.000 | +/-0.010 | 2.000 | ✓ | | | |
| 3.396 | +/-0.010 | 3.396 | ✓ | | | |
| 3.646 | +/-0.010 | 3.646 | ✓ | | | |
| 4.000 | +/-0.010 | 4.008 | ✓ | | | |
| 1.525 | +/-0.010 | 1.528 | ✓ | | | |
| 2.475 | +/-0.010 | 2.476 | ✓ | | | |
| Ø0.323 | +0.006/-0.001 | .324 | ✓ | | | |
| 0.080 | +/-0.010 | .073 | ✓ | | | |
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|------------------------|----------------------|----------------------------|-----|
| Measured by: RB | Audited by: S | Prototype Approval: | N/A |
| Date: 10-6-21 | Date: 10/6/22 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 06.09.08 | New Issue | KJ/JLM | |

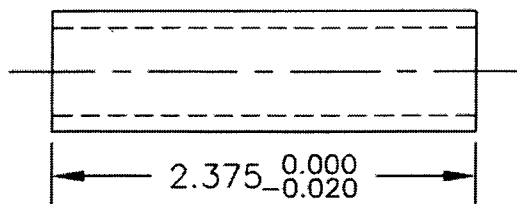
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT

DART

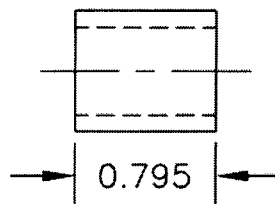
WITHOUT NOTICE
WORK ORDER

NO.

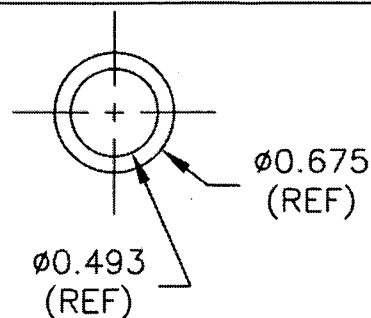
| | | | |
|-------------------------------|---------------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2282 | REV. E SHEET 1 OF 2 |
| DATE 05.06.07 | TITLE HANDLE TUBES SCALE 1:1 | | |
| A | 94.10.14 | NEW ISSUE | |
| B | 95.03.23 | RE-DESIGN | |
| C | 97.10.20 | CORRECTED NUMBERING SCHEME | |
| D | 05.03.16 | REDESIGN D2282-5; 0.795 WAS 0.750 | |
| E | 05.06.07 | D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030 | |



D2282-3

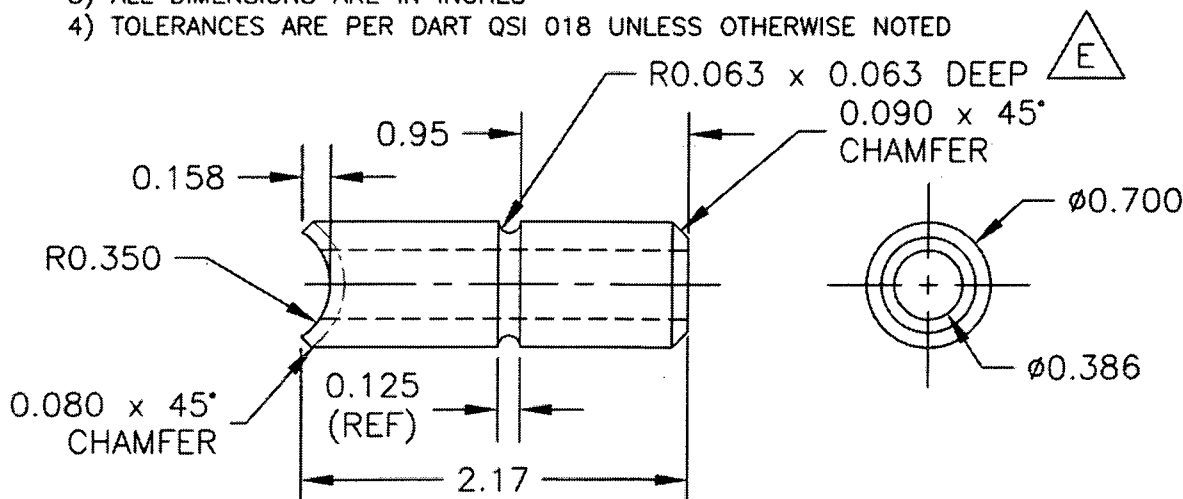


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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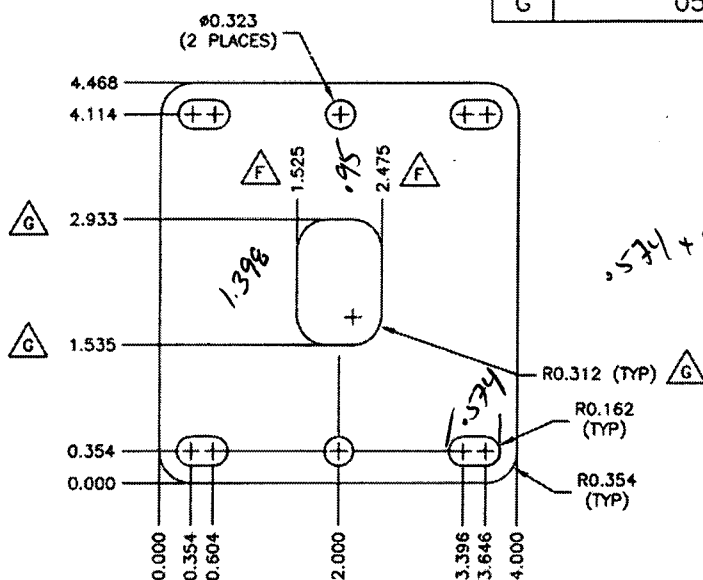
NOTE: Date & initial all entries

DART

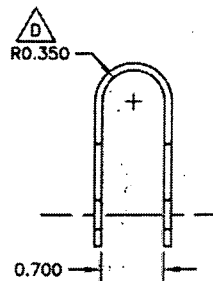
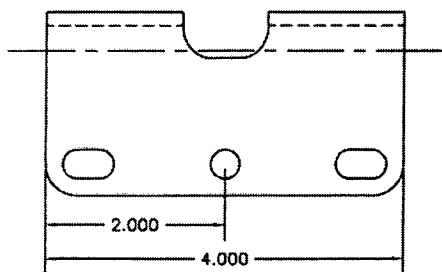
| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2281 | REV. G SHEET 1 OF 1 |
| DATE 05.06.07 | | TITLE JACK SADDLE | SCALE 1:2 |
| A | 94.10.14 | NEW ISSUE | |
| B | 94.10.18 | DIMENSION WAS 2.878 | |
| C | 94.11.04 | ADD TOOLING NOTCH | |
| D | 98.03.27 | R0.350 WAS R0.280 | |
| E | 04.11.18 | REMOVE TOOLING NOTCHES | |
| F | 05.03.16 | REDESIGN FLAT PATTERN | |
| G | 05.06.07 | REDESIGN FLAT PATTERN | |

RELEASED

05/08/11



FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
WORK ORDER
NO. 353704
P210-6-11

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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